

Data

Engine	115.923/926 115.938/939	115.951 115.954
Standard dimension	87.000 87.022	93.750 93.772
	87.500 87.522	94.150 94.172
Repair stages	88.000 88.022	94.550 94.572
	88.500 88.522	—
Max. wear limit in forward or transverse direction		0.10
	when new	0.013
Perm. out-of-true and conicity	wear limit	0.05
Permissible deviation vertically in relation to crankshaft center line, with reference to cylinder height		0.05
Perm. roughness		0.002–0.004
Perm. waviness		50 % of roughness
Chamfer of cylinder bores		refer to fig. item 2

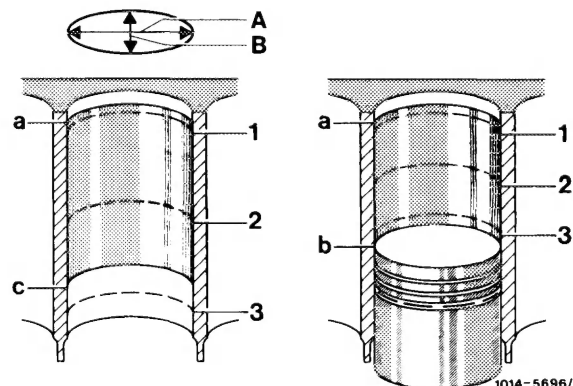
Note

Measure the clean cylinder bores with internal measuring instrument at measuring point 1, 2 and 3 in longitudinal direction A (piston pin center line) and in transverse direction B.

When pistons are not removed, the measuring point 3 is just above piston, which should be at BDC.

Measuring points 1–3

- A longitudinal direction
- B transverse direction
- a Upper reversing point of 1st piston ring
- b BDC of piston
- c Lower reversing point of oil wiper ring



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Chamfer cylinder bores after boring.

For honing, the material allowance should not exceed 0,05 mm.

